

Work Order ID 54949

January 5, 2010 10:18:16 AM



Page 1

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/06/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *RL*Date: *10-1-05*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *11041* Description: D3186-2MDoor Supplier:
Delastek Conformity Certificate and Process sheet required Ship 3 Items from
Previous steps

CL 10/01/06 ①

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure a copy of certification of conformity and process sheet from Delastek is
attached.

RL 1/3/31 ①

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Check for void spot and pins.

*8 10/04/05**⑦*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54949

Page 2

January 5, 2010 10:18:16 AM

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 18/1/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 100406 0.00

Packaging

Memo

0.00

Packaging

BT

100406

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/07

MF

10-4-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 10:18:21 AM

Page 1

Work Order ID: 54949



Parent Item: D3186-2M



Parent Item Name: SPACEPOD DOOR RH

Start Date: 05/01/2010

Required Date: 18/01/2010

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3186-2P

Purchased

No

100

Each

0.0000

1.0000



Spacepod Door

~~B 24869~~
~~B 24689~~
54949



ET 10-04-06

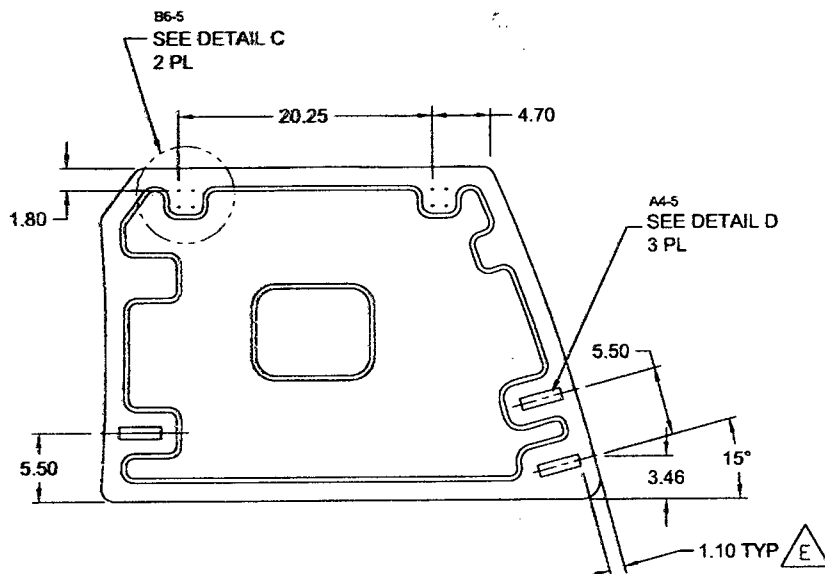
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

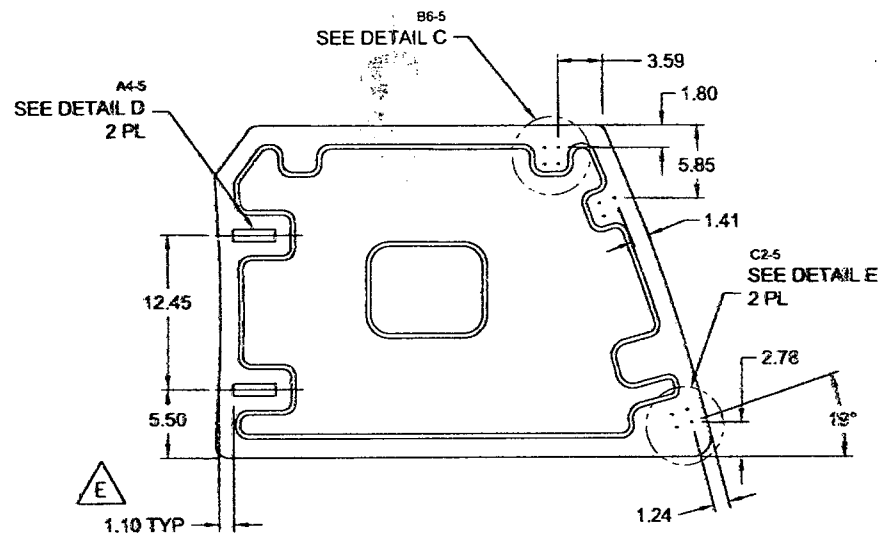


D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54949
0101-05



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-08

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN BS-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN BS-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN. UPDATED D3186-1M/2M/3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3186	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD DOOR	KTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED BY COMMANDING TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

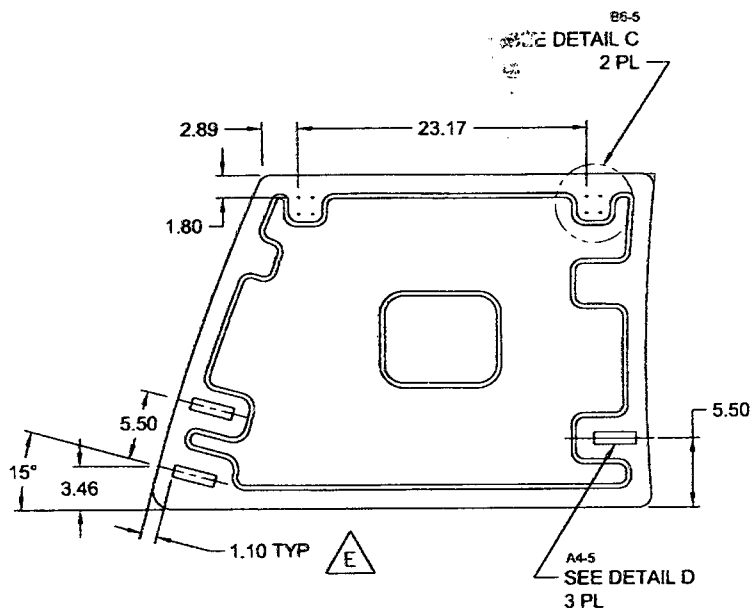
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

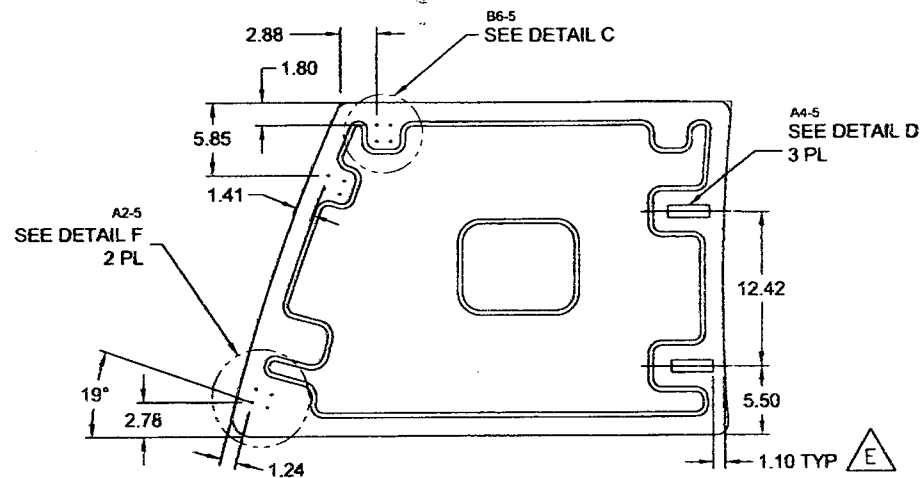
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	W	DRAWING NO.	REV. E
MFG. APPR.	W	D3186	SHEET 2 OF 5
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DE APPR.	W	SPACEPOD DOOR	NTS
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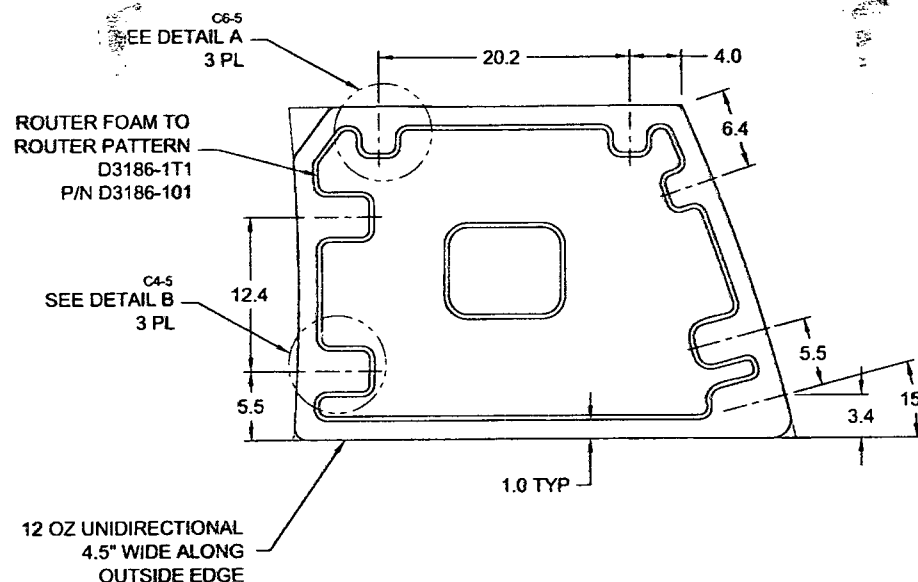
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
2009-08-08

WIC 54949

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3186	SHEET 3 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD DOOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

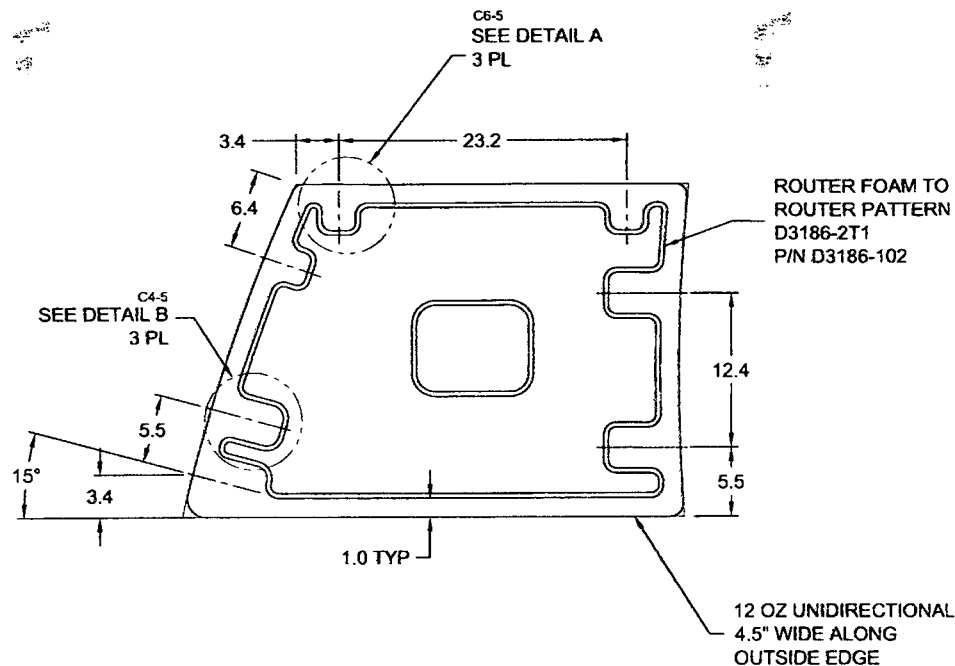
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



NOTES:

1) MATERIAL:

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 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
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 LAMINATION SCHEDULE PER THIS DRAWING

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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
 2009-08-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. E
MFG. APPR.	NT	D3186	SHEET 4 OF 5
APPROVED	NT	TITLE	SCALE
DE APPR.	NT	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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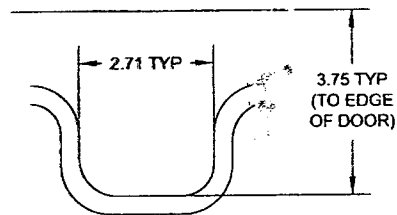
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

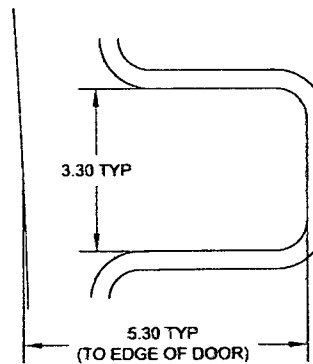
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

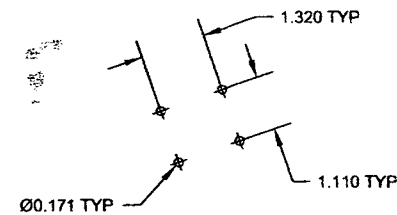
NOTE: Date & initial all entries



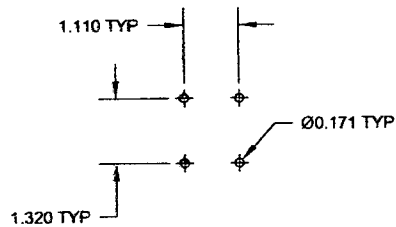
DETAIL A D6-3
SCALE 4X D4-4



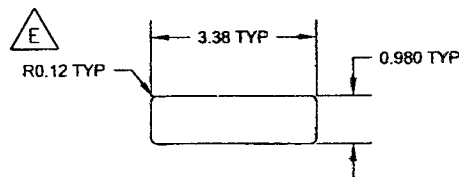
DETAIL B C6-3
SCALE 4X C6-4



DETAIL E C1-1
SCALE 4X

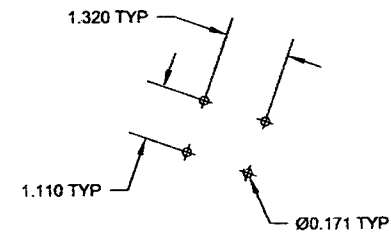


DETAIL C D7-1
SCALE 4X D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D C5-1
SCALE 4X D4-1
B6-2
C2-2



DETAIL F C4-2
SCALE 4X

RELEASED
2009-09-19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	U	DRAWING NO.	REV. E
MFG. APPR.	U	D3186	SHEET 5 OF 5
APPROVED	U	TITLE	SCALE
DE APPR.	U	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11041

Purchase Order Date 1/06/10

PO Print Date 1/07/10

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK COMPOSITES INC.
2699 5E AVENUE, LOCAL C.P 123

REVISED

GRAND-MERE, QC G9T 5K7
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	819 533 5788	Requisition Nbr	
Vendor Fax	819 533 3494	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3186-2P	Spacepod Door	4/02/10 Yes	✓ 1.00 Each	Purolator ground	\$711.0000	\$711.0
		Special Inst:	AS PER DWG D3186 REV. E B54949				
2	D3188-2P	Spacepod Body	4/02/10 Yes	✓ 1.00 Each	Purolator ground	\$2,177.0000	\$2,177.0
		Special Inst:	AS PER DWG D3188 REV. F B54945				
3	D3186-2P	Spacepod Door	4/16/10 Yes	1.00 Each	Purolator ground	\$711.0000	\$711.0
		Special Inst:	AS ABOVE B54948				
4	D3188-2P	Spacepod Body	4/16/10 Yes	1.00 Each	Purolator ground	\$2,177.0000	\$2,177.0
		Special Inst:	AS ABOVE B54944				

1/07/10



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13327
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
31/03/2010	06/01/2010	6084	Chantal Lavoie		PO11041		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0060 8/10/04/05	Line #1 D31862P Spacepod Door RH B45949 U de M : Each Dwg. Rév.: E No. lot Qté 24689 1			
1	0	1	DKC134-0071	Line #2 D31882P, Spacepod Body RH B54945 U de M : Each Dwg. D3188 Rév.: F No. lot Qté 24022 1			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357



Date: Mardi, 2010-03-02 14:04:21
Utilisateur: Louis Jodoin

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD DOOR RH
Numéro Job	: 24689	Numéro Article	: DKC134-0060
Numéro Soumission	: 3769	Numéro Dessin	: D3186
Numéro B.A.	:	Projet Numéro	: DK-359
Cette fois	: 2010-03-02 No. B.V. :	Révision dessin	: E
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: - - Type :	Date Due	: 2010-03-09
Job précédente	: 24033	Qté:	1 Udm: UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D31862M		

Process Sheet Rév.: 00 création du premier à partir du
DKC134-0058 dans Delastek Aéronautique

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009

Date: Sceau:

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)

4.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.5 VERGE(s)/Unit Total : 4.5 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26083-1

8.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)

Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24689

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

9.0

AMB0349

Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

10.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 03 mars 10 Sceau:



11.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

12.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26643-1

13.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 5-3-10 Sceau:



14.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 5-3-10 Sceau:



Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24689

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

15.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 9:20

Heure Fin Curing: 2:10

Date: 5-3-10 sceau:



16.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-26643-1

18.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core

Date: 3-3-14 sceau:



19.0

DKC134-0057

Foam Core N° D3186-102 (Porte D3186-2)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 (Porte D3186-2)

de Job: 44039

20.0

AAC1611

Polybond B46F

Commentair Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)

Polybond B46F

N° de Lot: 1-25391-1

21.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Utilisateur: Louis Jodoin

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24689

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 5-3-10

Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 2 heures minimum

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 2:30

Heure Fin Curing: 3:40

Date: 5-3-10

sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22126-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-26643-1

25.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 8-3-10

Sceau:



26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 8-3-10

Sceau:



Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 24689

Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 9:00

Heure Fin Curing: 8:00

Date: 8-3-10 sceau:



28.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges selon IG 0018.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 9 mars 10 Sceau:



29.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 9 mars 10 Sceau:



30.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26006-1

31.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26804-2

32.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008

Date: 12/03/10 Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24689

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: _____ Sceau: _____

Date: _____ Sceau: _____

Date: _____ Sceau: _____

33.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.020 KIT(s)/Unit Total : 0.020 KIT(s)
MASTIC POLYSOFT SIKKENS 3AR591

de Lot: 1-7129-1

34.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

de Lot: _____

35.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du sikkens.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Heure début Curing: _____

Heure Fin Curing: _____

Date: 16-3-10 sceau: _____



36.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)
Dupont Primer N° 7704S

de Lot: 1-26000-1

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase

de Lot: 1-26575-5

38.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer une couche de primer selon IG 0008

Date: 15/03/10 Sceau: _____



Date: 16-03-10 Sceau: MA

Date: 17-03-10 Sceau: MA

Date: _____ Sceau: _____

Date: Mardi, 2010-03-02 14:04:21
Utilisateur: Louis Jodoin

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24689

Nom Dessin: SPACEPOD DOOR RH
Numéro Article: DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

39.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 18-3-10 Sceau:



40.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 18-03-10 Sceau:

